

## Work Order ID 79040

January-18-12 3:54:03 PM

**\*79040\***

Page 1

Item ID: D3372-7

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Slider Body

Start Date: 18/01/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan: MVFDate: 12/01/10

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 1.250" x 4.435" long

OK 12/06/285

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3372-7 as per Folio FA495 and Dwg D3372 Identify as D3372-7Debur

OK 12/06/295

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 12/06/295

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**\*79040\***

Page 2

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**\*5\***

**Cust Item ID:**

**\*5\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Date:**

**Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

**Date:**

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

QC8- Inspect parts - second check

0.00

**\*130\***

0.00

QC

## Memo

## Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

0.00

HandFinish

## Memo

## Hand Finishing

~~QC3- Inspect Part Finish~~

0.00

**\*150\***

0.00

OC

## Memo

## Quality Control

W/O: 79040		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DB3	—	PERMANENT CHANGE. QC 7. SEQUENCE 150	AK	DB-3.			

Part No: D3372-7 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Work Order ID 79040

**\*79040\***

January-18-12 3:54:03 PM

Page 3

Item ID: D3372-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Slider Body  
 Start Date: 18/01/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Small Fab	0.00							
<b>*160*</b>									
Small Fab	Memo	0.00				52			12/07/03
Small Fab	Fabricate D3372-9 using AN6-36A bolt. Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.								
				12-07-03		5			
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
<b>*180*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:45 OVEN TEMPERATURE:								
	FINISH TIME: 4:15								
	3200F								
						SX			12/07/03

mill 3645

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*79040\***

Page 4

January-18-12 3:54:03 PM

Item ID: D3372-7

Accept

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Setup Start **\*NS1\***

Revision ID:

Item Name: Slider Body

Stop **\*NS2\***

Start Date: 18/01/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
<b>*190*</b>									
QC	Memo	0.00				5x	4	11	11/02/10
Quality Control									
200	Identify as per dwg & Stock Location: <u>ST 492</u>	0.00							
<b>*200*</b>									
Packaging	Memo	0.00				5x			SP
Packaging									12-7-4.
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							12/1/4
Quality Control									

12-07-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January-18-12 3:54:07 PM

Page 1

Work Order ID: 79040

\*79040\*

Parent Item: D3372-7

\*D3372-7\*

Parent Item Name: Slider Body

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A05.01.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN6-36A		Purchased	No			110	Each	50.0000	1	5			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

\*AN6-36A\*

Bolt

\*\*

Location

Loc Qty

Loc Code

ST342

50

118422

2

119449

1

120187

47

M6061T6B1.500X01.25  
0

Purchased

No

160

f

13.1170

0.3833

2.017368

\*M6061T6B1 500X01 250\*

6061-T6 Bar 1.50 x 1.25

\*\*

Location

Loc Qty

Loc Code

MAT003

13.117

118071

0.112

119513

13.005

M120660

2.02

amt 12/06/28

EP 12/07/23

M120423  
502

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79090
<b>Description:</b> Slider Body		<b>Part Number:</b>	D3372-7
<b>Inspection Dwg:</b> D3372 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.005	.750	—		Vern MK-06	
0.313	+/-0.005	.312	—			
2.108	+/-0.010	2.107	—			
1.50	+/-0.030	1.503	—			
0.63	+/-0.030	.630	—			
4.31	+/-0.030	4.312	—			
1.19	+/-0.030	1.191	—			
0.613	+/-0.010	.613	—			
2.938	+/-0.010	2.936	—			
1.375	+/-0.010	1.375	—			
0.200	+/-0.010	.200	—			
Ø0.323	+0.005/-0.000	Ø.323	—			
0.500	+/-0.010	.490	—			
0.881	+/-0.010	.888	—			

<b>Measured by:</b> <i>ml</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/06/29	<b>Date:</b> 12/06/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

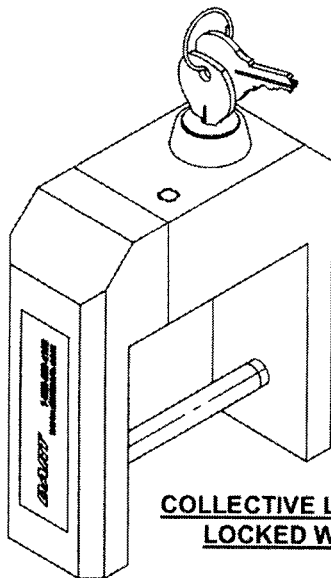
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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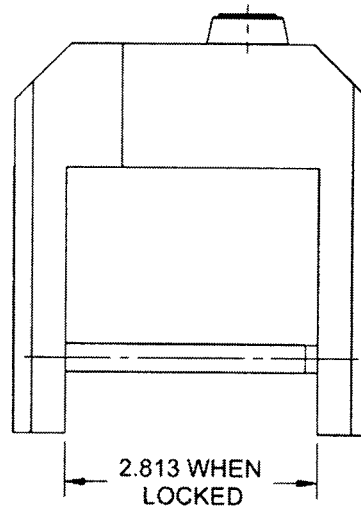
**NOTE:** Date & initial all entries



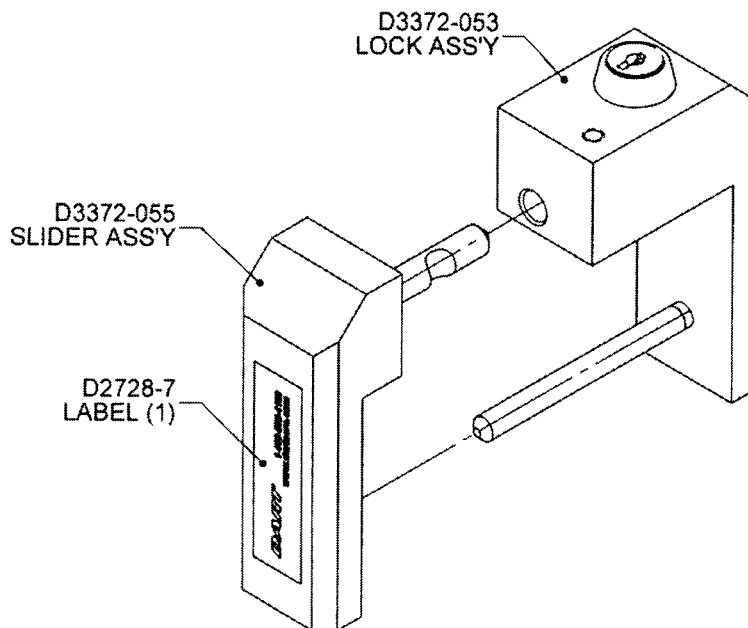
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3372</b>	REV. B SHEET 1 OF 8
DATE <b>05.02.23</b>	TITLE <b>COLLECTIVE LOCK</b>		SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



2.813 WHEN  
LOCKED



**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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05/04/28

UNCLASSIFIED COPY  
SAC, NEW YORK

79040 M.C.J.  
12/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

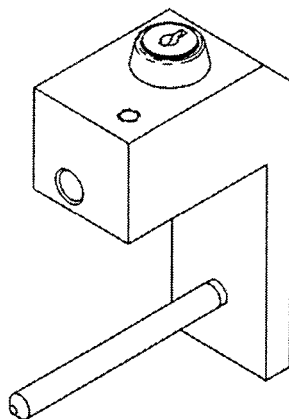
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 2 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



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*[Signature]*  
01/04/22

D3372-1  
MAIN BODY (1)

D3372-3  
GUIDE (1)

A

2

A

D3373-1 CAM <sup>B</sup>  
LOCK ASSY (1)

5/16 WC SS.  
FLAT WASHER (2)  
(AS PER D3371)

D3369-5 SPACER (1)  
(AS PER D3373-1)

TACK WELD  
D3372-5  
TO D3369-5

D3372-5 CAM  
LOCK SHAFT (1)

**SECTION A-A**

**D3372-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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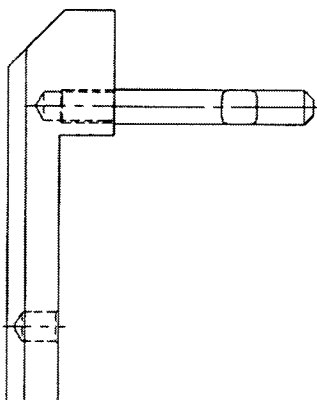
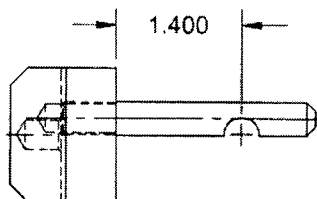
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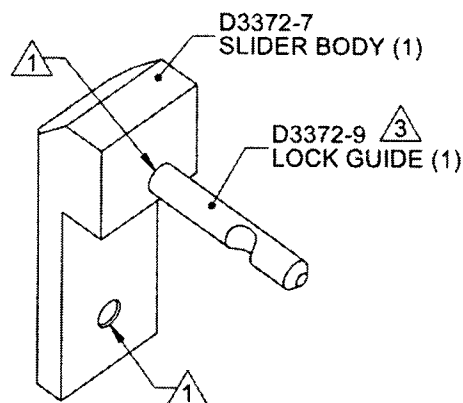


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 3 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



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*[Signature]*  
05/04/23



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

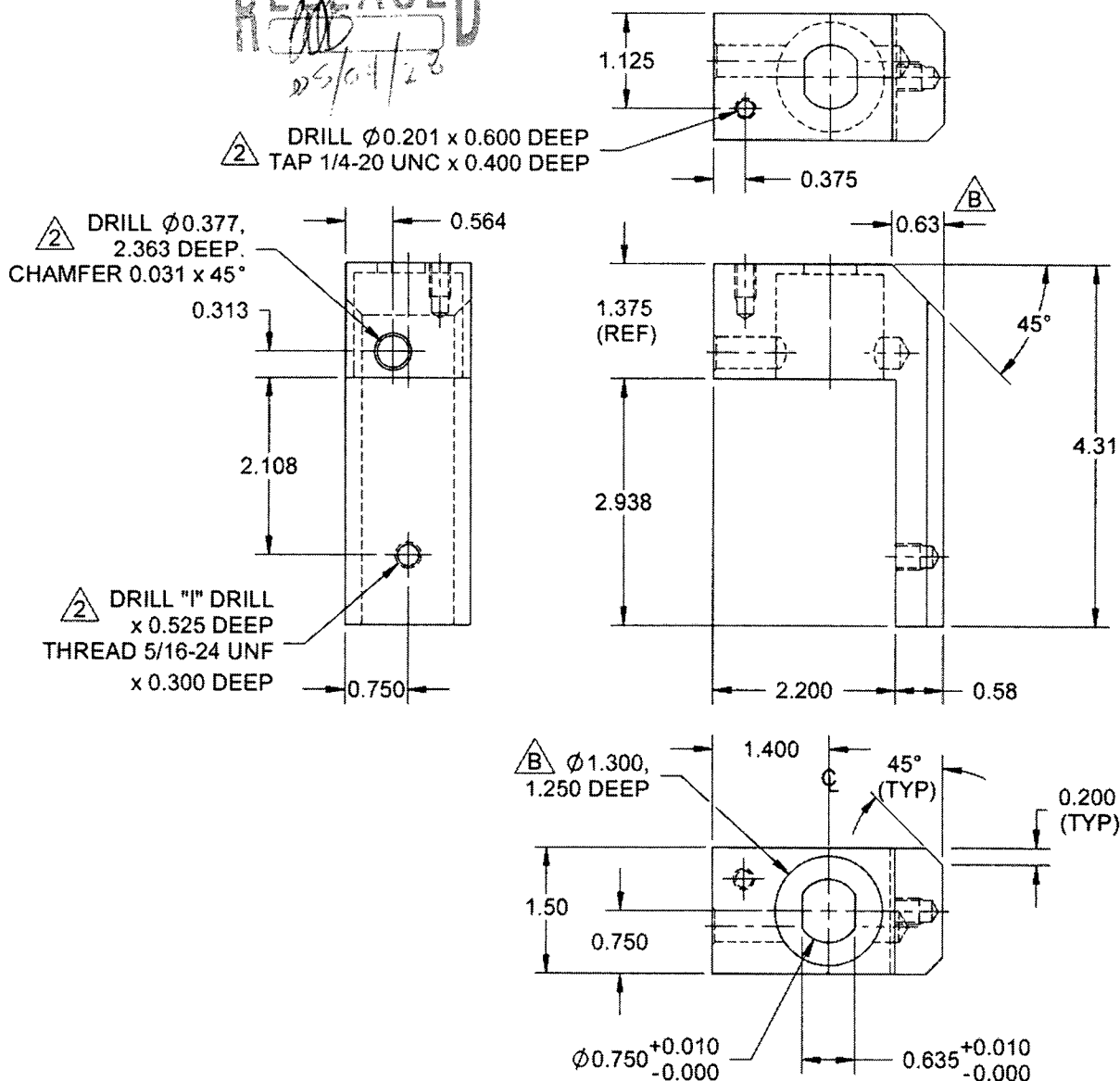
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

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*[Signature]*  
05/04/23



### D3372-1 MAIN BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTE: Date & initial all entries

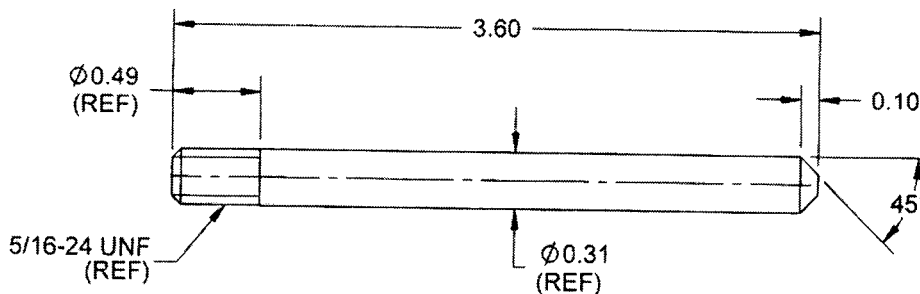


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 5 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

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*[Signature]*  
05/04/23



### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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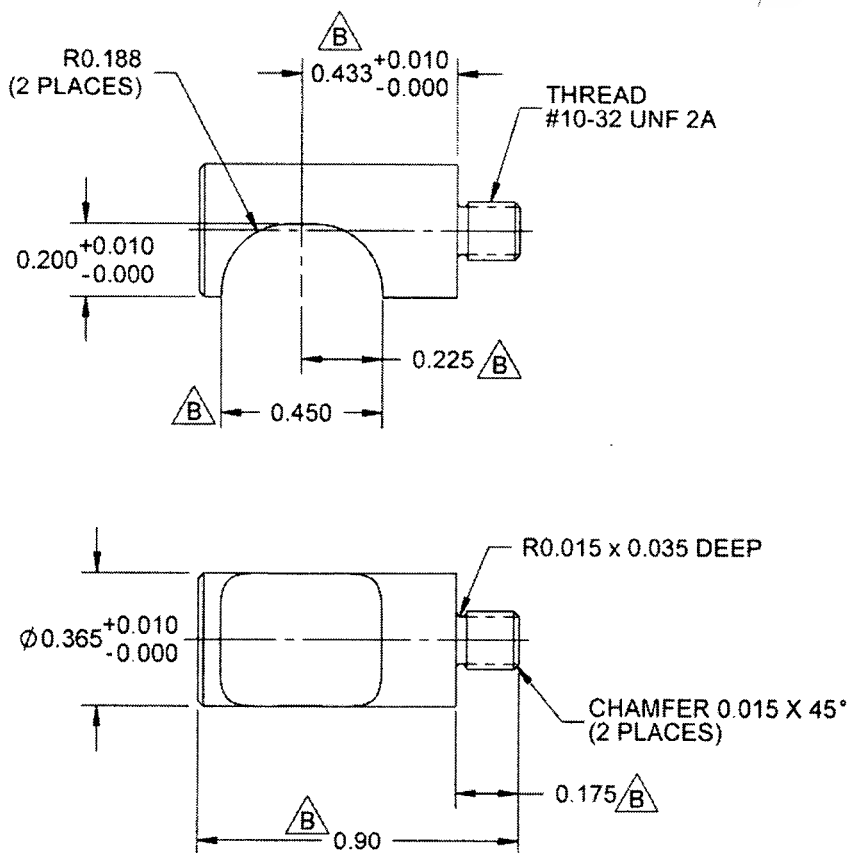
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 3	DRAWN BY [Signature]	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED TH	APPROVED [Signature]	DRAWING NO. <b>D3372</b>	REV. B SHEET 6 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 2:1

RELEASED  
[Signature]  
05/04/28



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

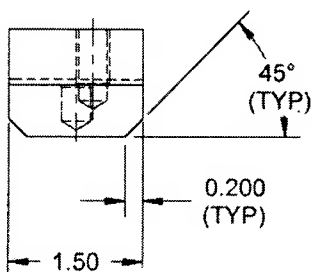
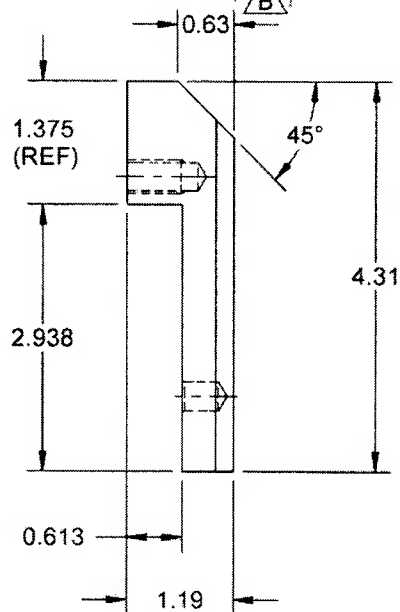
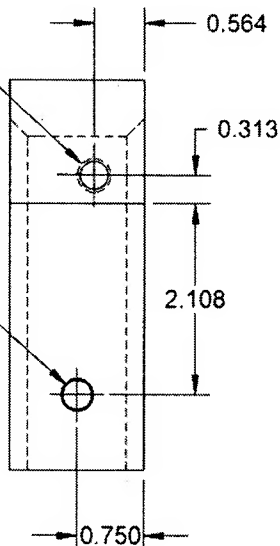




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 7 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

DRILL  $\varnothing 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\varnothing 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### **D3372-7 SLIDER BODY**

#### **NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

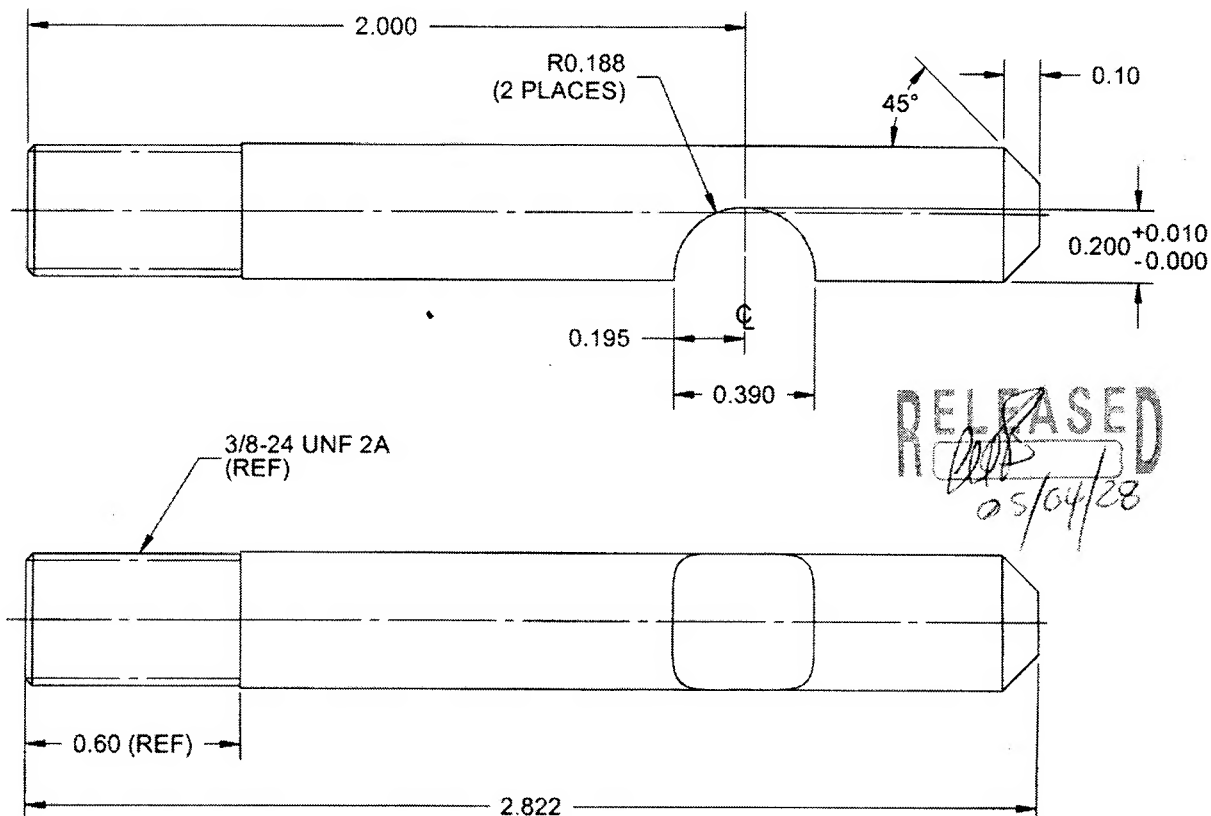
NOTE: Date & initial all entries



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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 8 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries